

Work Order ID 93058

November-13-12 3:08:40 PM

93058

Page 1

Item ID: D3027-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip

Start Date: 13/11/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 12-11-13 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3027	Rev B								
110	HAAS CNC VERTICAL MACHINING #1	0.00							
110									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT AS PER FILE								
<u>2024</u> <u>050</u>	PROG REV: <u>B</u>								
	DWG REV: <u>B</u>								
	DEBURR								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
120									
QC	Memo	0.00							
Quality Control									

(6)

12-11-27

(6)

12-11-27

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Accept

N900040100

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

DAS
15
12/11/27

6

Quality Control

140

Small Fab

0.00

140

Small Fab

Memo

0.00

6

SAB
12/11/29

Small Fab

Bend as per dwg D3027

150

QC5- Inspect part completeness to step on W/O

0.00

150

QC

Memo

0.00

DAS
15
12/11/29

6

Quality Control

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Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

160

HandFinish

Memo

0.00

Hand Finishing

6 26 2.11.27

170

QC3- Inspect Part Finish

0.00

170

QC

Memo

0.00

Quality Control

DAS
15
9-89
12/1/29

6

180

Identify as per dwg & Stock Location: ST024

0.00

180

Packaging

Memo

0.00

Packaging

6

12/11/30 AB

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Page 4

Item ID: D3027-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Clip

Start Date: 13/11/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 27/11/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept Reject Reject Insp.
Qty Qty Number Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

12/12/30
ML512-11-30

Picklist Print

November-13-12 3:08:44 PM

Page 1

Work Order ID: 93058

93058

Parent Item: D3027-5

D3027-5

Parent Item Name: Clip

Start Date: 13/11/2012

Required Date: 27/11/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP B01.09.27Now goes on HAASSM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M2024T3S.050

Purchased

No

100

sf

171.1984

0.0312

0.131368

1.

M2024T3S 050

**

B12-11-27

2024-T3 .050 sheet

Location

Loc Qty

Loc Code

MAT022

171.1984204

117684

11.8

121216

45.6484204

121889

113.75

121889

⓪

DART AEROSPACE LTD		Work Order:	75028 07070
Description: Clip		Part Number:	D3027-5
Inspection Dwg: D3027 Rev: B			Page 1 of 1

☒ First Article ☐ Prototype

[illegible]

DAS
15

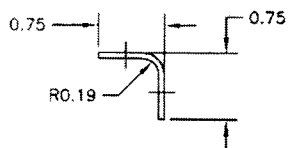
Measured by: <u>B</u>	Audited by: <u>Y-89</u>	Prototype Approval:	N/A
Date: <u>12-11-27</u>	Date: <u>12/11/27</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	05.04.26	New Issue P/O D350-689-013	KJ/JLM	
B	06.03.09	Dwg Rev upated	KJ/JLM	

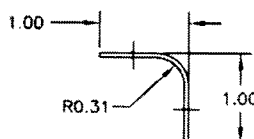


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DATE 05.09.20		TITLE CLIP	SCALE 1:2
A	01.05.18	NEW ISSUE	
B	05.09.20	REMOVE HOLES FROM -7	

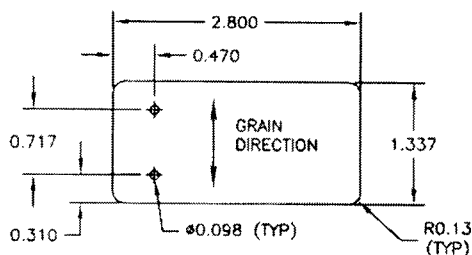
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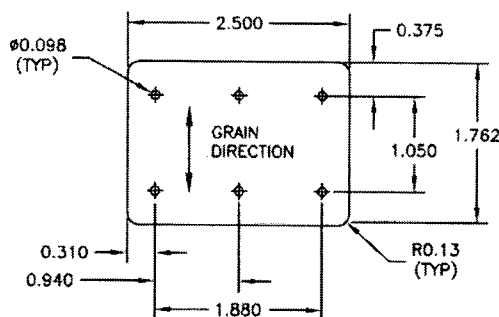
D3027-1 BEND DETAIL



D3027-3 BEND DETAIL



D3027-1 FLAT PATTERN
(0.063" SHEET)



D3027-3 FLAT PATTERN
(0.050" SHEET)

NOTES:

- 1) BREAK ALL UNMARKED SHARP CORNER 0.010 TO 0.020
- 2) MATERIAL: 2024-T3 (QQ-A-250/4)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
93058 12-11-05

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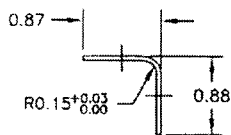
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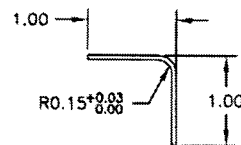
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DATE 05.09.20		TITLE CLIP	SCALE 1:2

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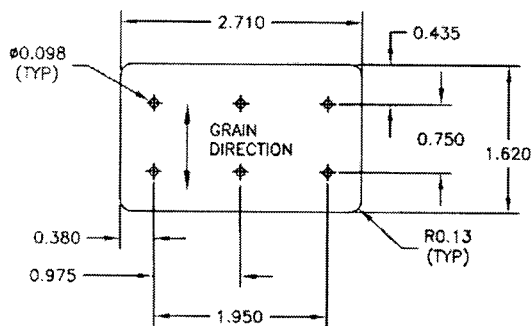
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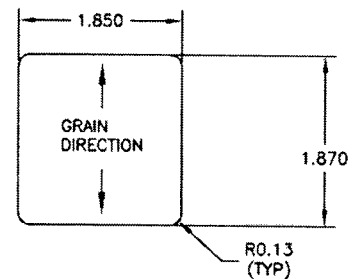
D3027-5 BEND DETAIL



D3027-7 BEND DETAIL



D3027-5 FLAT PATTERN
(0.050" SHEET)



D3027-7 FLAT PATTERN
(0.050" SHEET)

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